

Claims:

- 1 1. A spa assembly comprising:
2 a shell portion including a tub portion, a flat upper flange, and an integral spillway,
3 and shaped to be fitted into an existing gunite spa cavity, with the flat upper flange being
4 constructed so as to support the weight of the spa on the rim of the gunite spa cavity; and
5 plumbing elements associated with the shell portion, including at least one suction
6 and one return.
- 1 2. The spa assembly of claim 1 wherein the shell portion has a notch in the transition
2 area between the tub portion and the flat upper flange, wherein the notch is sized so as to
3 receive masonry components comparable to those to be placed on the top surface of the flat
4 upper flange.
- 1 3. The spa assembly of claim 2 wherein the notch has dimensions from between four to
2 six inches in height to one to two inches in depth.
- 1 4. The spa assembly of claim 1 wherein the shell portion includes a vacuum-formed
2 base part and a layer of fiberglass.
- 1 5. The spa assembly of claim 4 wherein the vacuum-formed base part is constructed
2 from a material selected from the group consisting of acrylic, plastic, Lucite, resin
3 composite, and carbon fiber.

1 6. The spa assembly of claim 1 wherein the shell portion is constructed so as to be
2 readily insertable and removable from the existing gunite spa cavity.

1 7. The spa assembly of claim 1 wherein the suction includes at least one main drain
2 suction, located near the bottom of the shell portion.

1 8. The spa assembly of claim 1, wherein operating controls are located in a single,
2 readily accessible window region.

1 9. A spa assembly comprising:
2 a shell portion including a tub portion, a flat upper lip having a top surface, and an
3 integral spillway; and
4 plumbing elements associated with the shell portion, including at least one suction
5 and one return;
6 wherein the shell portion is shaped so that it may be readily installed into an existing
7 gunite spa cavity, with the flat upper lip being constructed so as to allow flat masonry
8 components to be laid/installed directly onto the top surface.

1 10. The spa assembly of claim 9, wherein the assembly is capable of being installed in a
2 balanced manner, supported by both the flat upper lip and the bottom footwell, without the
3 use of sandbags.

1 11. The spa assembly of claim 10, wherein the assembly is capable of being attached to
2 an upper rim of the gunite spa cavity by securing elements.

1 12. The spa assembly of claim 11, wherein the securing elements are bolts.

1 13. The spa assembly of claim 11, wherein the securing elements are twist-lock
2 fasteners.

1 14. The spa assembly of claim 12, wherein the securing elements travel directly down
2 through the upper lip and attach to the gunite spa cavity.

1 15. The spa assembly of claim 9 wherein the shell portion has a notch in the transition
2 area between the tub portion and the flat upper lip, wherein the notch is sized so as to
3 receive masonry components comparable to those to be placed on the top surface of the flat
4 upper lip.

1 16. The spa assembly of claim 15 wherein the notch has dimensions from between four
2 and six inches in height to one to two inches in depth.

1 17. The spa assembly of claim 9 wherein the shell portion includes a vacuum-formed
2 base part and fiberglass.

1 18. The spa assembly of claim 17 wherein the vacuum-formed base part is constructed
2 from a material selected from the group consisting of acrylic, plastic, Lucite, resin-based
3 composites, and carbon fiber.

1 19. The spa assembly of claim 18 wherein the suction includes at least one main drain
2 suction, located near the bottom of the shell portion.

1 20. The spa assembly of claim 9, wherein operating controls are located in a single,
2 readily accessible window region.

1 21. The spa assembly of claim 9, wherein the spa assembly is pre-plumbed and all of the
2 basic plumbing controls are located in a single, readily accessible window region.

1 22. A spa assembly comprising:
2 a shell portion including a tub portion, a flat upper lip, and an integral spillway,
3 shaped so that it may be readily inserted into an existing gunite spa cavity; and
4 plumbing elements associated with the shell portion, including at least one suction
5 and one return;
6 wherein the shell portion has a notch in the transition area between the tub portion
7 and the flat upper lip, which is sized so as to receive masonry components that provide a
8 matching, transition zone allowing the desired masonry to extend seamlessly into the water
9 line.

1 23. The spa assembly of claim 22 wherein the shell portion includes a vacuum-formed
2 base part and fiberglass.

1 24. A method of making a spa comprising:
2 providing a base having a flat upper lip;
3 applying fiberglass material to the base;
4 installing plumbing, including at least one suction and one return, in association with
5 the base; wherein the base, the fiberglass and the plumbing define an assembly; and
6 applying insulating material to the assembly.

1 25. The method of claim 24 wherein the base is vacuum-formed.

1 26. A method of making a spa comprising:
2 providing a base having a flat upper lip and an integral spillway;
3 applying fiberglass material to the base;
4 installing plumbing, including at least one suction and one return, in association with
5 the base, wherein the base, the fiberglass and the plumbing define an assembly; and
6 applying insulating material to the assembly.

1 27. The method of claim 26 wherein the base is vacuum-formed.

1 28. A method of making a spa comprising:

2 providing a base having a flat upper lip and a water line, wherein the base possesses
3 no orifices within the top eight inches of a water line for the purpose of acting as a skimmer;
4 applying fiberglass material to the base;
5 installing plumbing, including at least one suction and one return, in association with
6 the base; wherein the base, the fiberglass and the plumbing define an assembly; and
7 applying insulating material to the assembly.